

BLUE ship Oct. 25

Work Order ID 62628

October 5, 2010 1:03:09 PM

Page 1

Item ID: D2939-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 10/05/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2939

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

10.10.20

2

HAAS CNC vertical machine #1

Program part number and batch number. □1-Inspect part number and batch number are programmed correctly. □2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet □3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

10.10.20

2

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

10.10.20

2

Quality Control

1239

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62628

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Page 2

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		A.A 10/10/21		2			
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00		-) ml 10/10/21		x2	0		
151  SprayPaint Spray Painting	 Memo PRIME B 115967 DELFLEET BLUE B 115509 CLEAR BLUE B 115949	0.00 0.00				ml	10	10	26 (2)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 62628**

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Page 3

Item ID: D2939-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 10/05/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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161 QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

85 10-10-27 (23)

170 Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

C. 10/10/27 (2)

180 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/28 JMF  
10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October 5, 2010 1:03:08 PM

Page 1

Work Order ID: 62628

Parent Item: D2939-1

Parent Item Name: Saddle LH In, 206



Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: B□00.06.26□New DWG rev (mpp 2069)□EC  
IPP Rev:C As per Rev C 07-03-19 JLM □□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001		Manufactured	No			100	Each	4.0000	1	2			
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Saddle Billet



10.10.20

Location

Loc Qty

Loc Code

MAT40

4

61385

4

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 62628
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2939-1
<b>Inspection Dwg:</b> D2939 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140	Vernier all	.125	.125				
B	0.100	0.140	except where	.125	.125				
C	0.100	0.140	specified	.120	.120				
D	0.210	0.230	RQ-02	.225	.225				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.257	.257				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.112	.112				
O	0.540	0.560		.550	.550				
P	0.490	0.510		.502	.502				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.744	2.744				
S	0.240	0.270		.253	.253				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.250	1.270		1.260	1.260				
Y	1.565	1.585	DT8695 A/B	1.575	1.575				
Z	0.178	0.198	Rad gage	.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>RF</i>
Date: 10-10-20

Audited by: <i>H.A</i>
Date: 10/10/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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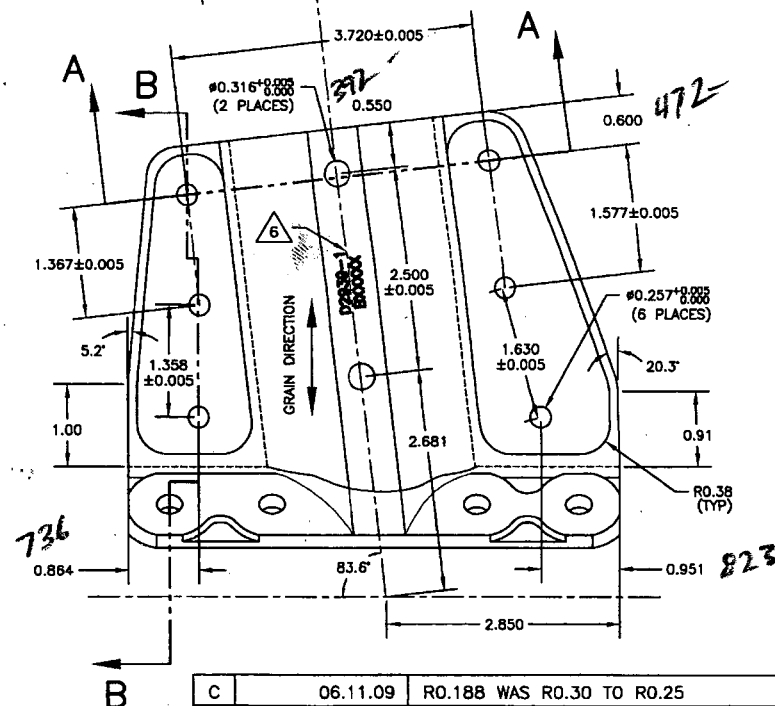
**NOTE:** Date & initial all entries




Technical drawing of a mechanical part, likely a bracket or support, showing dimensions and feature callouts. The drawing includes a vertical section on the left and a horizontal section on the right, connected by a curved transition.

Dimensions and Callouts:

- Vertical Section:**
  - Top edge:  $R0.188$  (AROUND POCKET) with feature callout **C**.
  - Inner corner:  $R0.50$  (TYP).
  - Inner edge:  $R1.575$ .
  - Inner edge:  $0.140$  and  $0.100$  with feature callout **B**.
  - Inner edge:  $1.000$ .
  - Inner edge:  $0.510 \pm \frac{0.005}{0.000}$ .
  - Inner edge:  $0.500$ .
  - Inner edge:  $0.115$ .
  - Inner edge:  $0.240$  and  $0.235$  with feature callout **B**.
  - Inner edge:  $R0.025$ .
  - Inner edge:  $1.605 \pm \frac{0.005}{0.000}$ .
  - Bottom edge:  $48.0^\circ$ .
- Horizontal Section:**
  - Top edge:  $2.725$  and  $2.675$  with feature callout **C**.
  - Inner edge:  $2.38$ .
  - Inner edge:  $0.325$  (circled).
  - Inner edge:  $2.2628$ .



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	 <b>DART AEROSPACE USA, INC.</b>
CHECKED	APPROVED	
DATE	TITLE	SCALE
06.11.09	SADDLE INSIDE	2:3

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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE USA, INC.

DESIGN

DRAWN BY

**DART** DART AEROSPACE USA, INC.

CHECKED

APPROVED
----------

DRAWING NO.	
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REV. G

DATE \_\_\_\_\_

TIME

SCALE

06.11.09

SADDLE INSIDE

2.5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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